Work Order	ID	53402
November 03, 2009	3:54	:40 PM

Η

Page 1

Item ID:

D2221

Accept

Setup Start

Stop



Revision ID:

350 Basket Base Item Name:

Start Date:

11/4/2009

Start Oty: 1.00 Required Date: 11/11/2009

Reg'd Oty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-11-03 Tooling:

Date: _____

SPC (Y/N):

0.00

0.00

Date:

Date:

Base converted for DSI 9473 installation

Start Run

Stop



Sequence ID/ Work Center ID Operation Description

Large Fab

Revision Nbr

Set Up/ **Run Hours** Draw Number Draw Plan Rev. Code

Reject Accept Qty

Qty

Reject Insp. Number Stamp

Draw Nbr D2221

Rev H

100

Large Fab

Large Fab

Memo

Memo

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per

dwg D2221

3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: M/09213

2 1.5 Drill holes for in D3825-041 pm QC9-Inspect visual per QS1004-Fusion Welds

gas sprily

(-143) (one side only)

PD 09.11.06

See Side Only)

110

Quality Control

0.00

Dart Aerospace Ltd

	-									
W/O:			WC	RK ORDER CHANGE	ES				. , , , , , , , , , , , , , , , , , , ,	
DATE	STEP	PROC	CEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	_ Fault Cate	gory:	NCR:	Yes N	lo DQ	A:	Date:	
	R	esolution:	_ Disposition	າ:	QA: N	C Clo	sed:		Date: _	
NCR:		W	ORK ORDI	ER NON-CONFORMA	NCE (I	VCR)	·			
DATE	STEP	Description of NC	Corrective Action Section			Verific	ation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID 53402

November 03, 2009 3:54:40 PM



Page 2

Item ID:

D2221

Н

Revision ID: 350 Basket Base

Item Name:

Start Date:

11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00 Reg'd Oty: 1.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: Tooling:

SPC (Y/N):

Date: Date: Run Start



Stop

Sequence ID/ **Work Center ID**

120

130

Quality Control

Operation **Description**

QC6- Inspect dimensions to drawing

Memo

Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Code

Accept Reject Qty Qty

Reject

Insp. Number Stamp

A pressure wash

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M112148

0.00

0.00

=> HP 09/11/09 (XI) Ø

Powdercoat

Powder Coating

Memo

1- Plug holes prior to

1ST COAT:

START TIME: 11:00 Am OVEN TEMPERATURE: 4009= FINISH TIME: 11:30Am

******************* 2nd coat if necessary**************

2ND COAT:

START TIME:

OVEN TEMPERATURE: 4000/2 FINISH TIME: 12:000

0.00

Dart	Aero	space	Ltd:
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W/O:			WO	RK ORDER CHANGI	ES			·	
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Ye	s No D O	QA:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NO	CR)			
DATE	STEP	Description of NC	Corrective Action Section		Verif	ication	Approval	Approval	
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Work Order ID 53402

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Page 3

Item ID:

D2221

Accept

Setup Start



Revision ID:

Н Item Name: 350 Basket Base

Stop

Start Date:

11/4/2009

Start Oty: 1.00

Cust Item ID: Customer:

Required Date: 11/11/2009

Rea'd Oty: 1.00

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Start



Date: _____

SPC (Y/N):

Date:

Draw

Stop

Sequence ID/ **Work Center ID**

140

OC

Ouality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ Run Hours

Number Rev. Bl 02-11-10

Draw

Otv Code

Plan

Accept Reject Qty

Run

Reject Insp. Number Stamp

PM 33 395 6000

150

OC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/12 A) MF 09-11-12

Dart Aerospace Ltd	Dart A	Aero	spac	e Ltd
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W/O:			WC	ORK ORDER CHAN	GES				
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Res	olution:	Dispositio	n:	QA: N/C (Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	MANCE (NC	R)			
DATE	E STEP Description of NC Corrective Action Section B					Verification Approx			Approval
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Picklist Print

November 03, 2009 3:54:39 PM

Work Order ID: 53402

D2221RevH

Parent Item Name: 350 Basket Base

Parent Item:



Start Date: 11/4/2009

Required Date: 11/11/2009

04-4-04-1-00

D : 100 100

Comments:								5	Start Qty: 1.	00	Required Qty: 1.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pic		Date Status Issued
D2221-1RevH	11 1 1 1 1 1 1 1 1 1	Manufactured	No			100	Each	23.0000	1.0000	SDO	69-11-65
				<u>Wareho</u>		Loc	Oty	Loc Code			
					<u>ation</u>						
				Main Wa	arehouse						
				ST	40101		1				
				Main Wa	48101		1				
				WA			22				
					51872		10			1 x	Mo9/11/04
					53213		12				
D2221-5RevH	#10110 1010 141 0110 611 611 1001	Manufactured	No			100	Each	6.0000	2.0000		
Rib										SAV	09-11-05
				Wareho		Loc	<u>Oty</u>	Loc Code			
					<u>ation</u>						
				Main W	arehouse		_				
				ST	53131		6 6				- IM
D2221-7RevH		Manufactured	No		33131	100	Each	3.0000	1.0000		- W J 09 111 104
		1/1441444444444								340	- Sy 09/11/04
Rib				Wareho	use	Loc	Oty	Loc Code			
				Loc	ation_						
				Main W	arehouse						
				WA			3				Mogliloy
					51251		3	•		-IX	_ NU 109 11104

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W/O:			W	ORK ORDER CHANG	ES		***************************************		,-
DATE	STEP	PRO	OCEDURE CH	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C C	losed:	· - · · · · · · · · · · · · · · · · · · ·	Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section	Verific	cation	Approval	Approvai	
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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Picklist Print

November 03, 2009 3:54:39 PM

Work Order ID: 53402

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Comments:



Start Date: 11/4/2009

Required Date: 11/11/2009

Page 2

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D2232-3RevC		Manufactured	No			100	Each	7.0000	2.0000	SAN	09 - U -	



Basket Hinge

Warehouse Location	Loc	<u>Otv</u>	Loc Code			
Main Warehouse						
ST		7	53344		1	
50024		2	~ ,			24 11
51870		5			I_{X}	09/11/04
	100	Each	16.0000	2.0000	. 18	- 111107
					_	

D2235-1RevB1 Manufactured No

Basket Rib

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
ST	3		
51438	3		
Main Warehouse			
WA	13		
50565	3		- IN A low
51871	10		-Da 59/11/04

D	art	Aer	OS	pad	ce	Ltd
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W/O:			WO	RK ORDER CHANC	GES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	Jory:	NCR: Yes	No DQ	A:	Date:	
		olution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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Work Order ID: 53402

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Comments:



Start Date: 11/4/2009

Required Date: 11/11/2009

Page 3

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D2581RevA1		Manufactured	No			100	Each	56.0000	2.0000			

Mounting Bracket

Shim

Warehouse	<u>Lo</u>	c Oty	Loc Code		
Location					
Main Warehouse					
ST		12			
46086		2			
48428		1			
51120		9			
Main Warehouse					
WA		44			
50872		1			0.1
51745		43			2x 09/11
	100	Each	14.0000	2.0000	
				3 6 6 1 6 6	_

D3442-1RevA

Manufactured

No

Warehouse Location	Loc Oty	Loc Code	
Main Warehouse			
ST	1		
46767	1		
Main Warehouse			
WA	13		

13

Bx Sy 09/11/04

50951

Dart	Aero	space	Ltd.
Duit	7010	Space	

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W/O:			WC	ORK ORDER CHANG	BES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	gory:	NCR: Yes	No DC	A:	Date:	
		solution:							
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval
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Work Order ID: 53402

Parent Item:

D2221RevH

Parent Item Name:

350 Basket Base

Comments:



Start Date: 11/4/2009

Required Date: 11/11/2009

Start Otv: 1.00

Required Oty: 1.00

									~ 3			
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	4.0000	2.0000	SAD	09-11	1-06
				Warehoo Loca	use ation	Loc	<u>Otv</u>	Loc Code				

D3826-041RevB

Manufactured

No

No

Main Warehouse ST 51869 100 Each 4.0000 2.0000

Rib / Gusset Assembly

<u>Warehouse</u>	Loc	e Oty	Loc Code	
Location				
Main Warehouse				
ST		4		
51340		4		
	100	Each	3.0000	1.0000

Manufactured

Rib Assembly (Inboard)

D3827-041RevA

Warehouse	Loc Qty	Loc Code
Location Main Warehouse		
ST	3	
51339	3	

1x Sy 09/11/04

Dart Aerospac	e Ltd	
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W/O:			W	ORK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
		solution:							
NCR:				ER NON-CONFORM					
DATE	STEP	Description of NC			ection B	Verific	ation	Approval	Approval
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Picklist Print

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Work Order ID: 53402

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Manufactured

No

Comments:



Start Date: 11/4/2009

Required Date: 11/11/2009

Page 5

Start Oty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-1RevA		Manufactured	No			100	Each	4.0000	1.0000			
										SAD	04-11-0-5	

Mesh (Base)

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
ST	2		
46306	1		
46774	1		
Main Warehouse			·
WA	2		
51863	2		Tx 20105
	100 Each	12.0000 2.0000	3037 3 111/03
			SAD 84-11-05

Mesh (Base End Face)

D3833-IRevA

			_
Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
ST	4		
51304	4		2x M 09/11/05
Main Warehouse			, ,
WA	8		
50025	2		
53214	6		

Dart Aerospace Ltd

W/O:			V	VORK ORDER CHANG	ES			<u> </u>	
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	s No D	QA:	Date:	
				QA: N/C Closed: Date:					
NCR:		,	WORK OR	DER NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC	Corrective Action Section			Ver	ification		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		ection C	Chief Eng	QC Inspector
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D2221 BASKET BASE ASSEMBLY (AS350) (MESH SHOWN LOCALLY FOR CLARITY) NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) (DENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	Х	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
_ 7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
. 9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

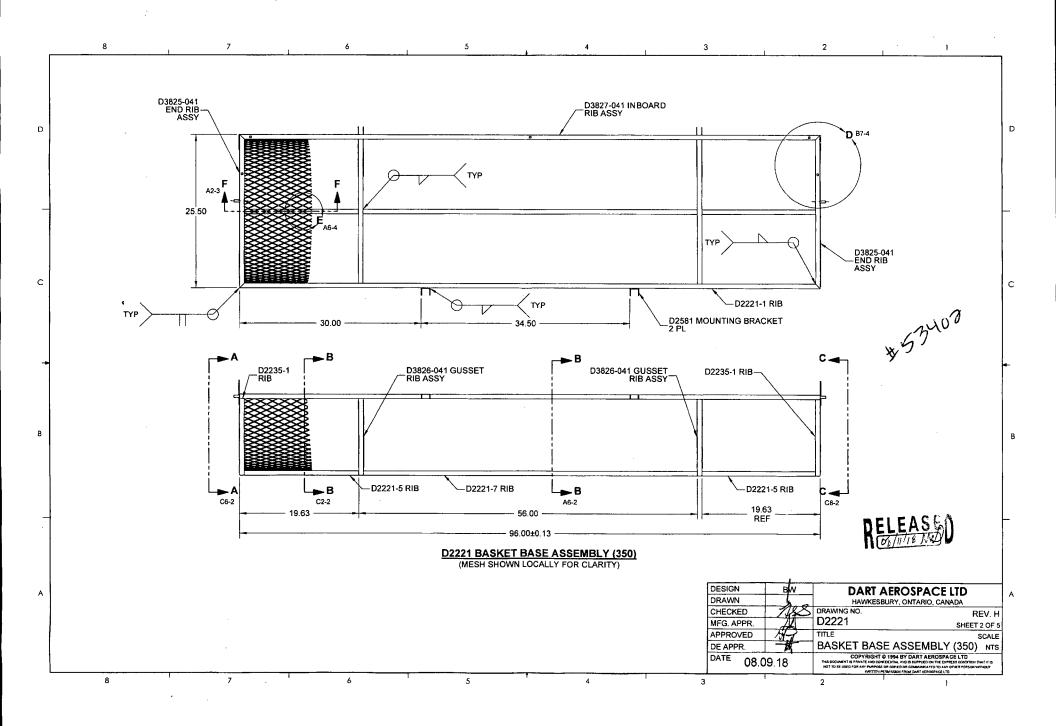
н	PARTS C-C (ZN 4); ADDI (ZN B2-4 (SHEET ZN B4-3 041 REF D2221-1	LIST (ZN D3-1) C6-3, C2-3 AN ED DETAIL E (I); ADDED DW 5); TOL REVIS); D3625-041 F CLACES D2235 ON INBOARD	AND ADDED "ITEM" COLUMN TO I; REVISED SECTIONS A. B-B AND ID A6-3); REVISED DETAIL D (ZM 87-ZM 64-1; ADDED SECTION F-F G DETAILS FOR D2221-1/-5/-7 SED TO 2 DEC PLACES (ZM D8-3 AND EPLACES D2221-3/02327-3: D3926-1/02325; D3927-041 REPLACES SIDE; ADDED D3832-1 AND D3933-1. EAN MANUFACTURING* PROGRAM.	мв	08.09.18	
G	TOLERA WAS RE NOW "R TO SHT	AL FOR -1, -3, INCE FOR 96, F (ZN 85-2); 1 EF" (ZN 84-2); 2; SHT 2 MES ERED TO "B"	SLA	08.06.16		
F	ADD SH BASKET	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET			05.06.07	
E	CHANG	E HINGE		СР	01.04.19	
D	CHANG	ELATCH		BW	96.06.21	
С	SEPARA	TE BASKET A	ND LID	КН	95.11.21	
REV.			DESCRIPTION	BY	DATE	
DESIG		BW	DART AEROSP			
CHECKED ILL			HAWKESBURY, ONTARIO, CANADA DRAWING NO.			

DRAWIN	<u></u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	1/25	DRAWING NO. REV. I
MFG. APPR.		D2221 SHEET 1 OF
APPROVED	W.	TITLE SCAL
DE APPR.	-6	BASKET BASE ASSEMBLY (350) NTS
DATE 08.0	09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD 745 DOCUMENTS OF MINATE AND COMPRESSION, NOT TO BE USED FOR ANY PARPOSE OF COMPLEX AT THE ANY OFFICE PRISON WITHOUT NOT TO BE USED FOR ANY PARPOSE OF COMPLEX AT THE ANY OTHER PRISON WITHOUT

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W/O:				V	ORK ORDER CHANG	ES				
DATE	STEP		PR	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	_ Date: _	
Resolution:					Disposition: QA: N/C Closed: Date: _					·
NCR:				WORK OR	DER NON-CONFORMA	ANCE (NCF	(3)			
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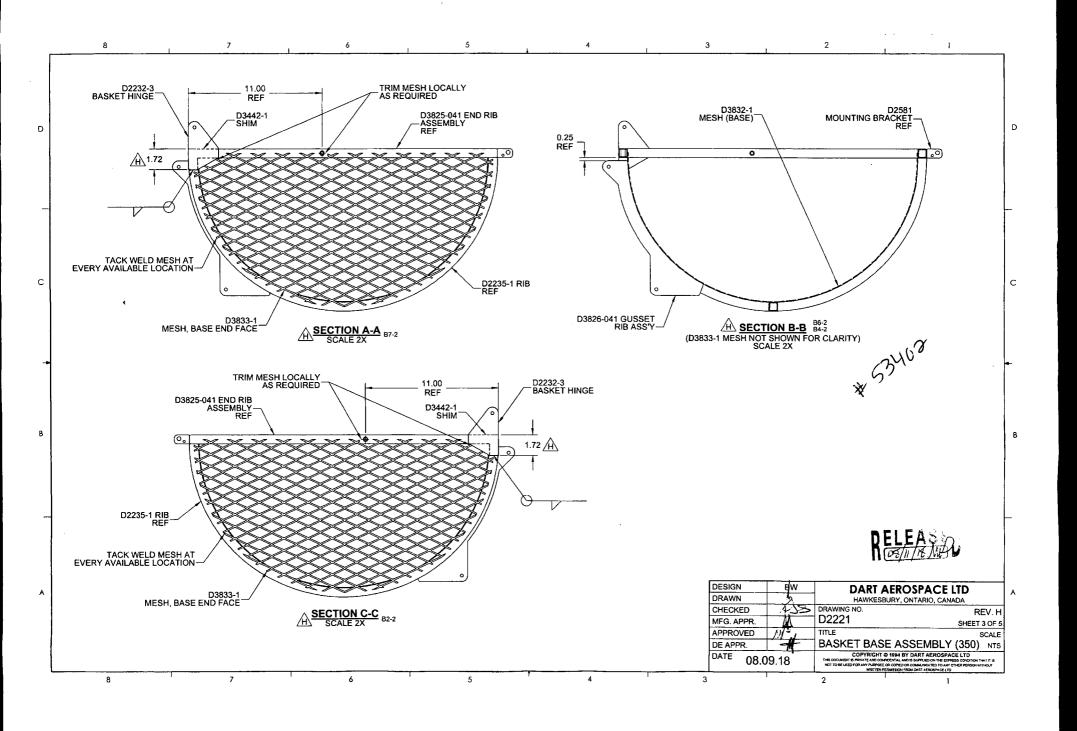
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DATE	STEP	PRO	IANGE	Ву	ı	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	es No	DQA	\ :	Date: _		
Resolution:			Disposit	Disposition: QA				QA: N/C Closed: D			
NCR:			WORK OR	DER NON-CONFORMA	NCE (N	CR)			*****		
DATE	STEP	Description of NC	Corrective Action Section			Verific		ation Approval	Approval		
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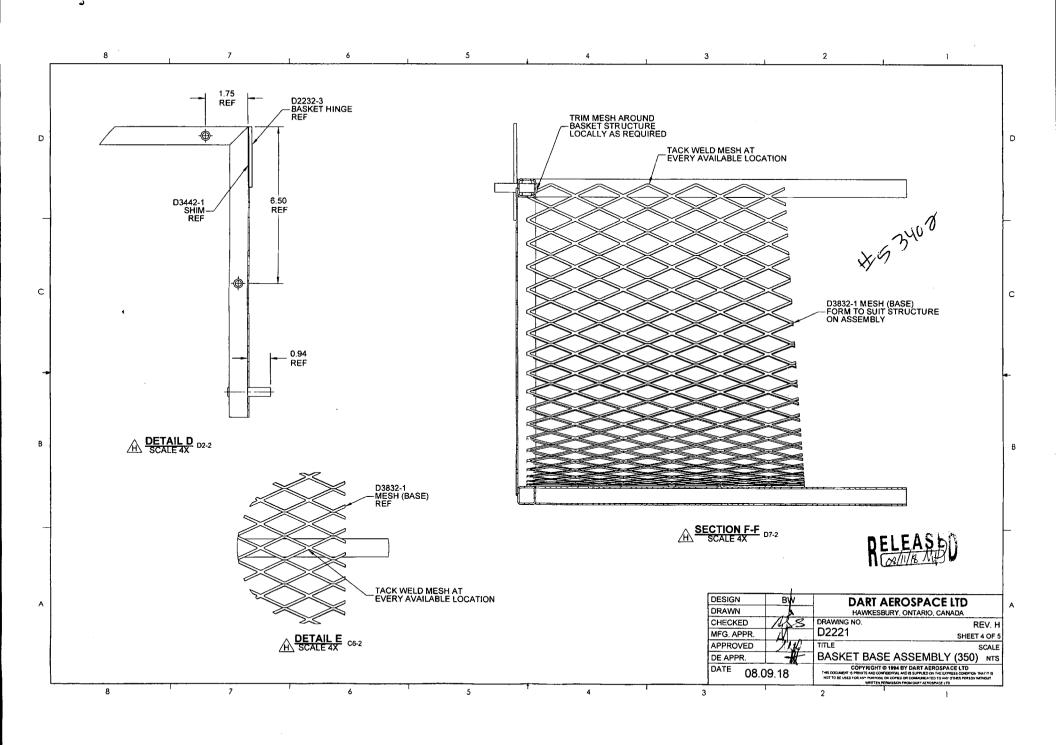
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Part No	•	PAR #:	Fault Cate	gory:	NCR:	: Yes I	No DQ	A:	Date:	7,404	
				Disposition: Q							
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DATE	STEP	Description of NC	Corrective Action Section B			Verifica			Approval	Approval	
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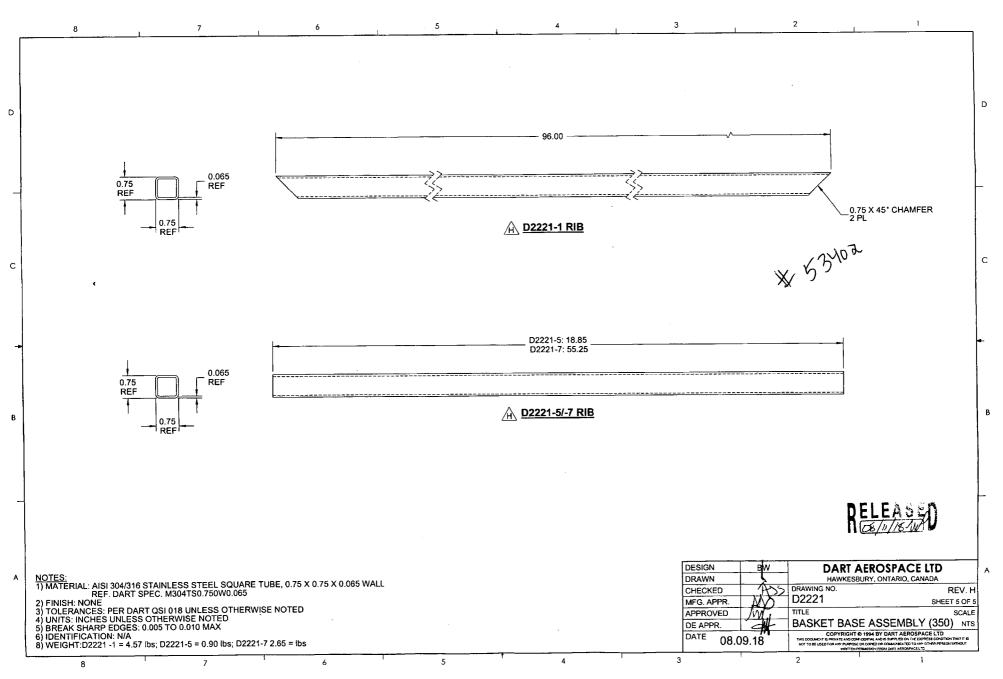
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DATE	STEP	PRO	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:						
			Disposition: Q			QA: N/C Closed: Date				:	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (N	CR)					
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Part No:		PAR #:	Fault Cated	jory:	NCR: Yes No DQA: Date:					
	R	esolution:	Disposition	1:	_ QA: N/C Clo	sed:	Date:			
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DATE	STEP	Description of NC Section A		Corrective Action Section		Verification	Approval	Approval QC Inspector		
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng			
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